

Work Order ID - 62475

Thursday, September 30, 2010 2:20:14 PM



Page 1

Item ID: D3659-1

Accept



Setup Start



Revision ID:

Item Name: CUFF

Stop



Start Date: 9/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

12

Date:

10-9-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3659	Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

10-10-5

4

Jeaspa Bandsaw

Cut blank 7.300" long

110

0.00



DOOSAN LATHE

Doosan

Memo

0.00

10-10-7

4

Doosan Lathe

1-Turn as per folio FA 707 & DWG D3659,
FOLIO REV: *1A*
DWG REV: *1B*
2-Deburr as required

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

10-10-7

4

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10/10/07

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-10-8

10/10/08

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 62475

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Page 3

Item ID: D3659-1

Accept

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Item Name: CUFF

Start Date: 9/30/2010 Start Qty: 4.00

Required Date: 10/8/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 477

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 30, 2010 2:20:17 PM

Page 1

Work Order ID: 62475

Parent Item: D3659-1

Parent Item Name: CUFF





Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6009-129  Crosstube Material		Manufactured	No			100	Each	18.0000	0.056 	0.235789		<i>10.10.10</i>	

Location

Loc Qty

Loc Code

LG

18

38342

2

53594

16

34597

2.416'

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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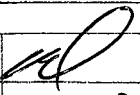

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DART AEROSPACE LTD		Work Order: 62475
Description: C4AF		Part Number: D3659-1
Inspection Dwg:	Rev:	Page 1 of 1

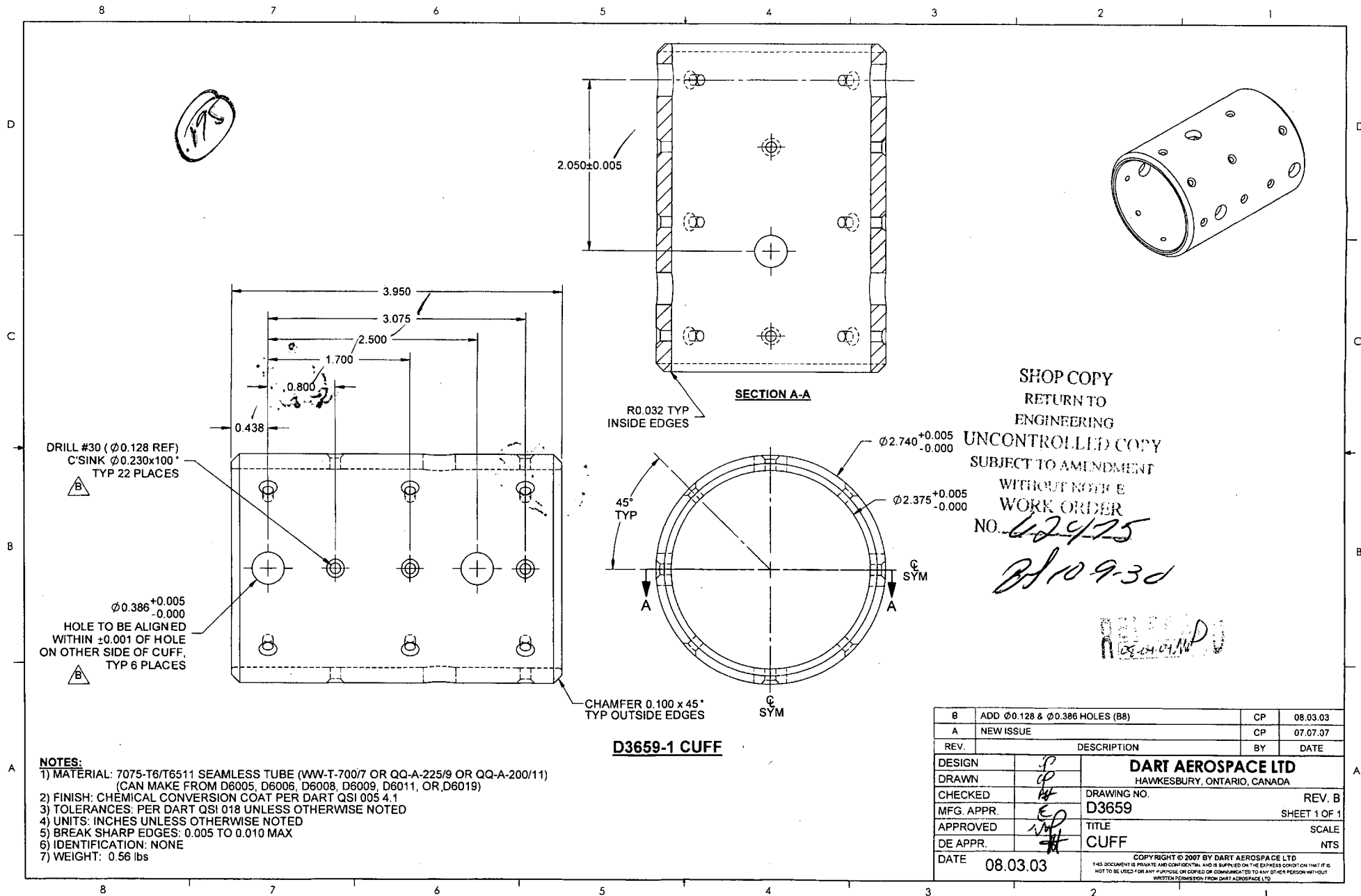
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.950	+/- .010	3.953	/			
3.075	+/- .010	3.075	/			
2.500	+/- .010	2.500	/			
1.700	+/- .010	1.700	/			
.800	+/- .010	.800	/			
.438	+/- .010	.438	/			
.128	+ .005 - .001	.128	/			
.230	+/- .010	.233	/			
100°	+/- 1/2°	100°	/			
.386	+ .005 - 0.0	.390	/			
2.050	+/- .005	2.050	/			
1.032	+/- .010	.025	/			
2.740	+ .005 - 0.0	2.743	/			
2.375	+ .005 - 0.0	2.378	/			

Measured by: 	Audited by: 	Preliminary Approval:
Date: 10.10.06	Date: 10/19/07	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

 10.04.15



W/O:		WORK ORDER CHANGES					
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